

Work Order ID 57357

April 6, 2010 8:56:29 AM



Page 1

Item ID: D206-642-541

Accept



Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 06/04/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 16/04/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date: 10-4-10 Tooling:

Date:

Run Start



QC:

Date: _____ SPC (Y/N):

Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3274	D								
IIN-D206-642	Rev M								

100



0.00

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D206-642-541

CHG003

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

110

Operation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Skidtubes

0.00

Skidtubes

Memo

0.00

****VERIFY AND INSPECT THE MATERIAL PRIOR TO USE****

1- Bend FWD end of tube using bend prog D3274 FWD dwg D3274, cut fwd end of tube with saw table setup D3274.

M10/04/12

2- remove fwd indexing ridge as per dwg D3274. Prepare for welding

DP 10-4-8
SE 10/04/12

3- weld fwd cap as per dwg D3274 and QSI004.

AR Aluminum Rod Batch: M112307 / M113207

4- grind fwd cap weld on top surface only

BL 10/04/12

5- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.

6- Drill Aft cap pilot hole using DT8025

7 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D.
Drill 3/16" pilot holes as per Dwg D3274

8 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe batch #

9 -Open aft end cap holes to 00.208" as per Dwg D3274. Deburr aft end.

AWM 10-04-15

W/O:		WORK ORDER CHANGES					
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Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



Chemical Conversion Coat per QSI005 4.1

0.00

1 - - *AM*
10-4-15

HandFinish

Memo

0.00

Hand Finishing

130



QC3- Inspect Part Finish

0.00

5/10/04/13

QC

Memo

0.00

Quality Control

140



QC5- Inspect part completeness to step on W/O

0.00

5/10/04/16

QC

Memo

0.00

Quality Control

(40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

150

Operation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Skidtubes

Skidtubes

0.00

Memo

0.00

1-Open Ø0.313" and 0.375" crossbolt spacer holes using DT8743 as per Dwg
D32742-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from
inside the tube

3-Bond web in place as per Dwg D3274 & QSI 015.

A/R Sikaflex-291 *10/12/29* Sikaflex expire date: *10/12/30* Start: *10/12/29* Time: *2.00* Finish: *10/15/29* Time: *10:30*

(Adhere for 12 hours)

10/14/19
10/14/17

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00


10/15/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

170

Operation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Skidtubes

Skidtubes

0.00

Memo

0.00

1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.

2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2
OPEN HOLES TO .297". Deburr3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD
END OF TUBE
DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)
REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

4- Countersink crossbolt spacer holes as per Dwg D3274

5- prepare for welding

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

 $H \ 3.0'$
 $L \ 4.6"$

BE 10/05/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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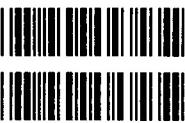
Setup Start



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Item Name: Replacement Skidtube

Stop



Start Date: 06/04/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 16/04/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

190

Operation
Description

Skidtubes

Set Up/
Run Hours

0.00

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Skidtubes

Skidtubes

Memo

0.00

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod

A/R Aluminum Rod M112507
SE 10/05/12

3-Grind cross bolt welds flush as per Dwg D3274.

10/05/13

4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.

200



QC

QC5- Inspect part completeness to step on W/O

0.00

S 10/05/13

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Cust Item ID:

Required Date: 16/04/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

210



QC

Quality Control

Operation
Description

QC10- Inspect visual per QSI004- ground welds

Set Up/
Run Hours

0.00

Draw
Number

Rev.

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

0.00

0.00

230



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

11/14/2017

0.00

0.00

Memo

START TIME: 9:00AM
OVEN TEMPERATURE: 320°F
FINISH TIME: 9:30AM

S10513

70

① BL 10-5-14.

① d

⇒ M 10/08/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Customer:

Reference:

Approvals:

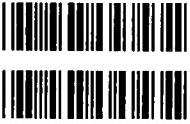
Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

240

QC3- Inspect Part Finish



QC

Quality Control

Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

0.00

D BL 10-5-19.

250



HandFinishing

0.00

0.00

HandFinish

Hand Finishing

1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets.
A/R□N/A□LPS-3□

① BL 10-5-19

2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a
A/R□□Sikaflex-291 □ *MU2429*.
Sikaflex expire date: □ *10/08*.

260



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

S 10/05/19 RU

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Customer:

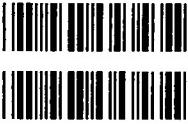
Reference:

Approvals: Process Plan: _____

Date: _____ Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____ SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberReject
Number
Insp.
Stamp

270



HAND FINISHING RESOURCE #1

HandFinish

Memo

0.00

Hand Finishing

1-Install wearpads & gaskets as per Dwg D3274.

2-Install ring as per Dwg D3274

A/R Sikaflex-291 112429
Sikaflex expire date: 10/08

3-Inspect for foreign objects as per QSI 024

4-Spray inside of tube on both sides of web with LPS-3

A/R LPS-3 Batch: _____

5-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/R Sikaflex-291 112429
Sikaflex expire date: 10/08

PROC40W 104251.

① BL 10-5-19

280



QC5- Inspect part completeness to step on W/O

0.00

S 10/05/10

QC

Quality Control

Memo

0.00

(M)

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Customer:

Reference:

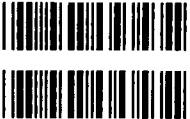
Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

290



Packaging

Packaging

Operation
Description

Identify as per dwg & Stock Location: _____

Set Up/
Run Hours

0.00

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

300



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

W/O:		WORK ORDER CHANGES					
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Picklist Print

April 6, 2010 8:56:34 AM

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Work Order ID: 57357



Parent Item: D206-642-541



Parent Item Name: Replacement Skidtube

Start Date: 06/04/2010

Required Date: 16/04/2010

Comments: IPP Rev:B 05.09.23 Revised per D206-642 Rev. J□KJ/JLM
IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM□
IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

D2600-1-190



Manufactured No

110 Each 50.0000 1.0000



Extrusion Round 3" 206

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

LG

50

47575

50

D3285-1



Manufactured No

110 Each 164.0000 1.0000



Cap

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

LG

164

47635

15

52511

74

52647

75

D3282-041



Manufactured No

150 Each 4.0000 1.0000



Float Web (206L/407)

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

LG

4

52696

4

D57539 ① 110/4/27

W/O:		WORK ORDER CHANGES					
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IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM □
IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

D2649



Manufactured No

190 Each 85.0000 1.0000



Cross Bolt Spacer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>	
Main Warehouse	85	858545	12
	55000		BE 10/05/12

D3275-1



Manufactured No

190 Each 20.0000 12.0000



Crossbolt Spacer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>	
Main Warehouse	20	858179	12
	53453		BE 10/05/12

CR3212-4-03



Purchased No

250 Each 219.0000 2.0000



Cherry Rivet

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>	
Main Warehouse	219		
	111359 ✓	92	2 BR 10-5-19
	112314	127	

W/O:		WORK ORDER CHANGES					
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IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

D3415-041



Manufactured No

250

Each

75.0000

1.0000



Nut Plate

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST056

75

33842 ✓

75

CCR264SS3-3



Purchased No

250

Each

726.0000

2.0000



Cherry Rivet

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST311

726

111548 ✓

4

112314 ✓

4

113539 ✓

92

113973 ✓

626

ALS4-1032-130



Purchased No

250

Each

40.0000

78.0000



Insert

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST282

40

110511 ✓

40

1 BL 10-5-19

2 BL 10-5-19

78. BL 10-5-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 6, 2010 8:56:34 AM

Page 4

Work Order ID: 57357



Parent Item: D206-642-541



Parent Item Name: Replacement Skidtube

Start Date: 06/04/2010

Required Date: 16/04/2010

Comments: IPP Rev:B 05.09.23 Revised per D206-642 Rev. J□KJ/JLM
IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM□
IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

D3536-15



Manufactured No

270

Each

19.0000

1.0000



Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

FP

19

51600

7

56055

12

1 BL 10-5-19

D3536-23



Manufactured No

270

Each

7.0000

1.0000



Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

FP

7

57529

7

53468

1 BL 10-5-19

D3536-35



Manufactured No

270

Each

11.0000 1.0000



Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

FP

11

58687

11

1 BL 10-5-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 6, 2010 8:56:34 AM

Page 5

Work Order ID: 57357



Parent Item: D206-642-541



Parent Item Name: Replacement Skidtube

Start Date: 06/04/2010

Required Date: 16/04/2010

Comments: IPP Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM
IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM
IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

D3536-39



Manufactured No

270

Each

11.0000

1.0000



Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Main Warehouse

FP	11	
48161	1	
51637	10	

BL 105-19

D3535-15



Manufactured No

270

Each

14.0000

1.0000



Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Main Warehouse

FP	14	
53462	4	
56053	10	

BL 105-19

D3535-35



Manufactured No

270

Each

9.0000

1.0000



Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Main Warehouse

FP	9	
51608	9	

BL 105-19

W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 6, 2010 8:56:34 AM

Page 6

Work Order ID: 57357



Parent Item: D206-642-541



Parent Item Name: Replacement Skidtube

Start Date: 06/04/2010

Required Date: 16/04/2010

Comments: IPP Rev:B 05.09.23 Revised per D206-642 Rev. J □ KJ/JLM
IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM □
IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

D3535-39



Manufactured No

270 Each 9.0000 1.0000



Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

FP

51619 ✓

9
9

D3535-23



Manufactured No

270 Each 14.0000 1.0000



Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

FP

53467
560546 ✓

14
2
12

D3537-3



Manufactured No

270 Each 20.0000 1.0000



Wearpad

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

FP

57512
35697

20

1 BL 10-5-19

1 BL 10-5-19

1 BL 10-5-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 6, 2010 8:56:34 AM

Page 7

Work Order ID: 57357



Parent Item: D206-642-541



Parent Item Name: Replacement Skidtube

Start Date: 06/04/2010

Required Date: 16/04/2010

Comments: IPP Rev:B 05.09.23 □ Revised per D206-642 Rev. J □ KJ/JLM
IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM □
IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

D3537-1



Manufactured No

270

Each

51.0000

9.0000



Wearpad

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

FP 57256
55465

51

51

9 BL10-5-19

AN960C10L



washer

Purchased No

270

Each

0.0000

80.0000

NAS1144C0332R.

14341



80. BL10-5-19

AN960C416



washer

Purchased No

270

Each

377.0000 1.0000



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST346
100993 ✓

377

377

1 BL10-5-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

2010 8:56:34 AM

Work Order ID: 57357



Parent Item: D206-642-541



Parent Item Name: Replacement Skidtube

Comments: IPP Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM
 IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM
 IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
 IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC

Start Date: 06/04/2010

Required Date: 16/04/2010

Start Qty: 1.00

Required Qty: 1.00

D3672-1



Manufactured No

270

Each

1,589.000 2.0000



Phenolic Washer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST077	1589
47628	89
51674	500
52505	1000

2 BK 10-5-19

AN3C4A



Purchased No

270

Each

1,249.000 80.0000



BOLT

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST350 114523	1249
113226	248
114103	501
114108	500

80 BK 10-5-19

W/O:		WORK ORDER CHANGES			
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

April 6, 2010 8:56:34 AM

Work Order ID: 57357



Parent Item: D206-642-541



Parent Item Name: Replacement Skidtube

Start Date: 06/04/2010

Required Date: 16/04/2010

Comments: IPP Rev:B 05.09.23 Revised per D206-642 Rev. J□KJ/JLM
 IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM□
 IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
 IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

AN4C5A



Purchased No

270 Each 534.0000 1.0000



BOLT

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST346	534	DR 10-5-19
110552	34	
112243	500	

D2646



Manufactured No

270 Each 35.0000 1.0000



Aft Cap

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

FP6	28	BLR 10-5-19
52663	28	

Main Warehouse

fp7	7	
52663	7	

W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 6, 2010 8:56:34 AM

Page 10

Work Order ID: 57357



Parent Item: D206-642-541



Parent Item Name: Replacement Skidtube

Start Date: 06/04/2010

Required Date: 16/04/2010

Comments:

IPP Rev:B 05.09.23 □ Revised per D206-642 Rev. J □ KJ/JLM
IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM □
IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

D3413-1



Manufactured No

270

Each

31.0000

1.0000



Ring

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST473 58524	31	
51586 ✓	8	
53446	23	

1 HK 10-5-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN CP	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3274	REV. D SHEET 1 OF 4
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY	SCALE NTS
A	04.03.15	NEW ISSUE	
B	04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76	
C	05.03.16	ADD -043; NEW INSERTS	
D	06.12.19	NEW INSERTS, SS WEARSHOE + GASKET	

RELEASED

07.02.12 *#*

DEO ATTACHED

Qty -041	Qty -043	Part Number	Description	Shop Copy Return To Engineering Uncontrolled Copy Subject To Amendment Without Notice Work Order No. <i>52357</i>
X		D3274-041	SKIDTUBE ASSEMBLY	
	X	D3274-043	SKIDTUBE ASSEMBLY	
1	1	D2600-1-240	EXTRUSION	
1	1	D2646	AFT CAP	SHOP COPY
12	12	D2649	CROSS BOLT SPACER	RETURN TO
12	37	D3275-1	CROSS BOLT SPACER	ENGINEERING
1	1	D3282-041	FLOAT WEB	UNCONTROLLED COPY
1	1	D3285-1	CAP	SUBJECT TO AMENDMENT
1	1	D3413-1	RING	WITHOUT NOTICE
1	1	D3415-041	NUT PLATE	WORK ORDER
1	1	D3535-15	WEARSHOE	
1	1	D3535-23	WEARSHOE	
1	1	D3535-35	WEARSHOE	
1	1	D3535-39	WEARSHOE	
1	1	D3536-15	GASKET	
1	1	D3536-23	GASKET	
1	1	D3536-35	GASKET	
1	1	D3536-39	GASKET	
9	9	D3537-1	WEARPAD	
1	1	D3537-3	WEARPAD	
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)	
80	80	AN3C4A	BOLT	
1	1	AN4C5A	BOLT	
1	1	AN960C416	WASHER	
80	80	AN960C10L	WASHER	
2	2	CCR264SS3-3	RIVET	
2	2	CR3212-4-03	RIVET	
2	2	NAS1515H3L	WASHER	

GENERAL NOTES:

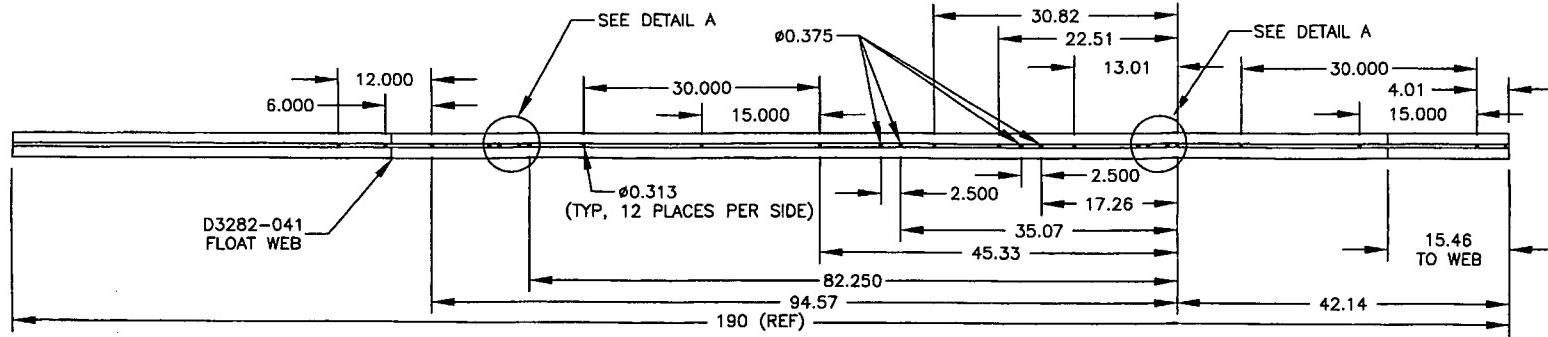
1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

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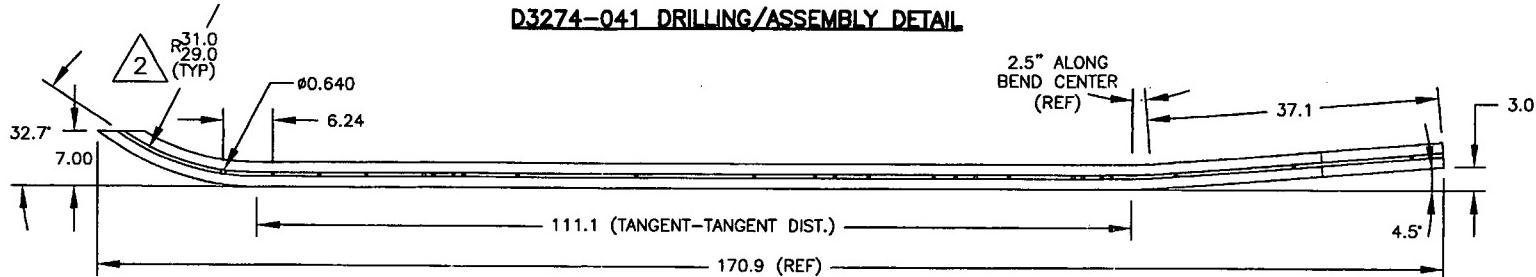
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BS 10-4-06

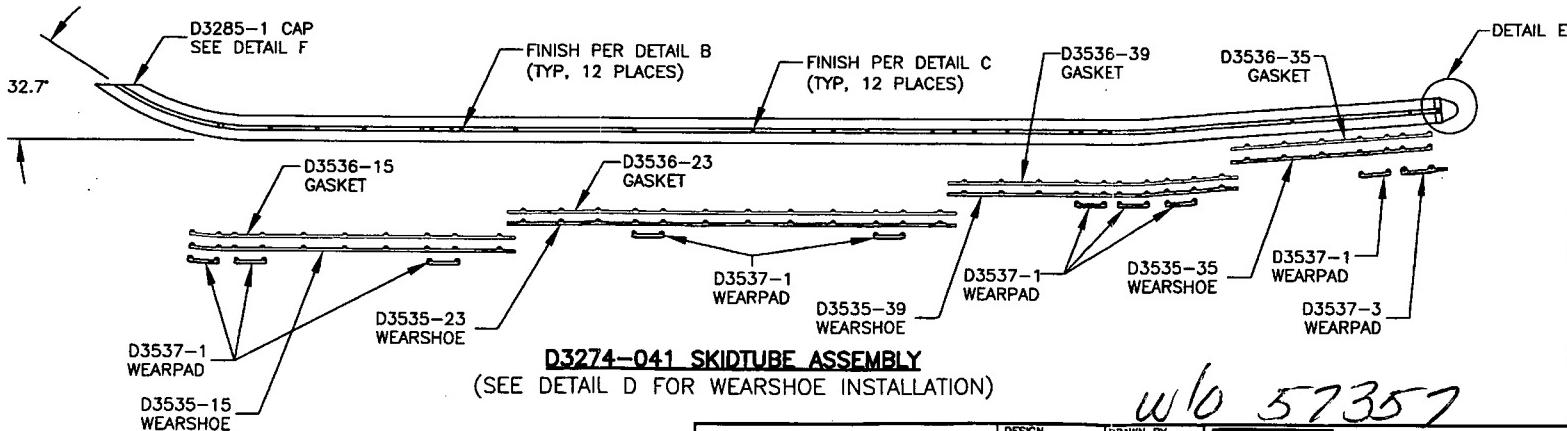
DEO ATTACHED



D3274-041 DRILLING/ASSEMBLY DETAIL



D3274-041 BEND/DRILLING DETAIL



D3274-041 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

RELEASED

07.02.12

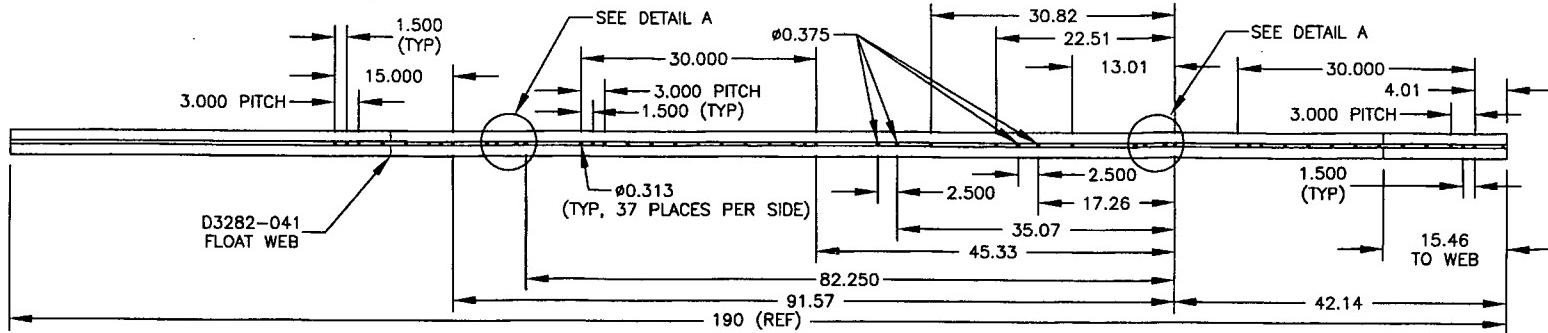
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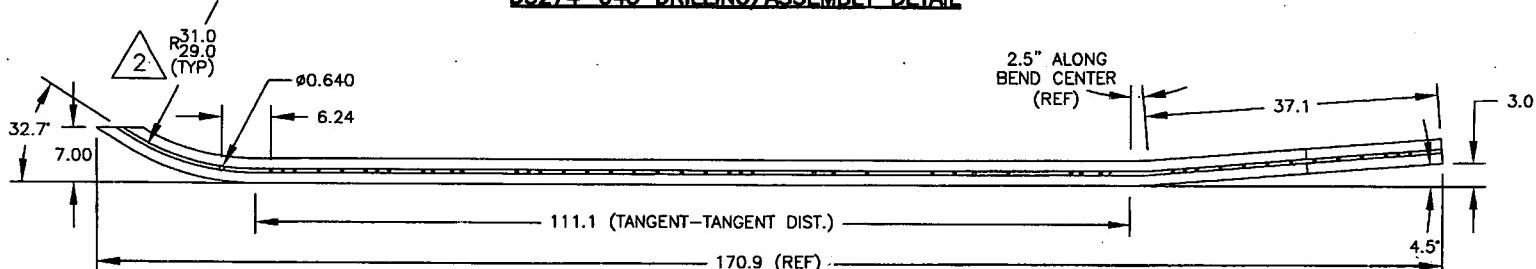
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CHECKED	#	APPROVED	#	DRAWING NO.	D3274
DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY	REV. D	SHEET 2 OF 4
SCALE	1:15				

wb 57357

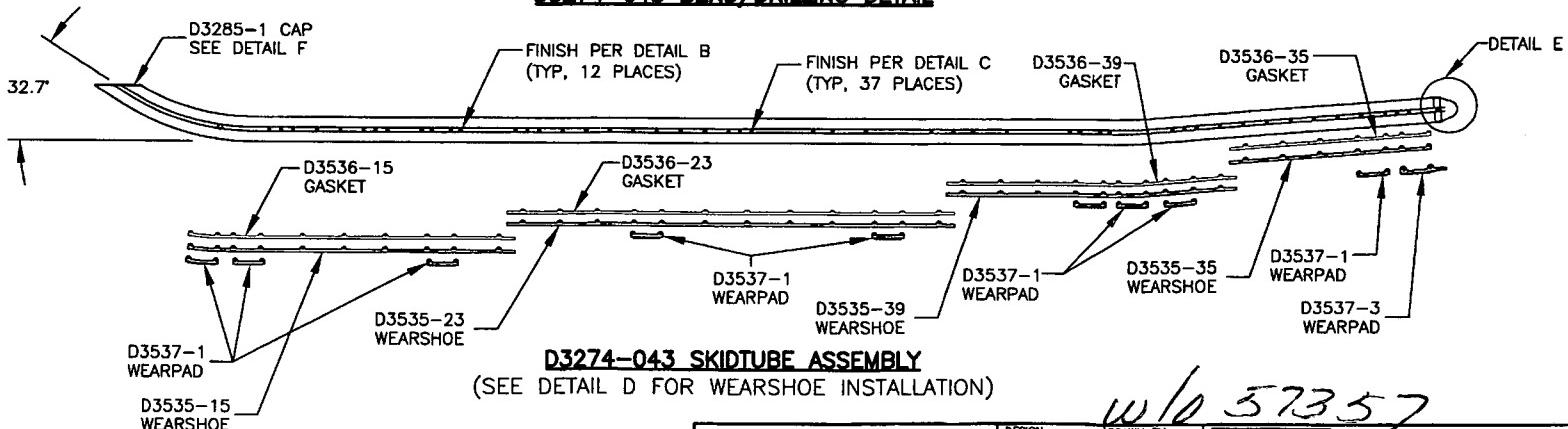
DEO ATTACHED



D3274-043 DRILLING/ASSEMBLY DETAIL



D3274-043 BEND/DRILLING DETAIL



RELEASED

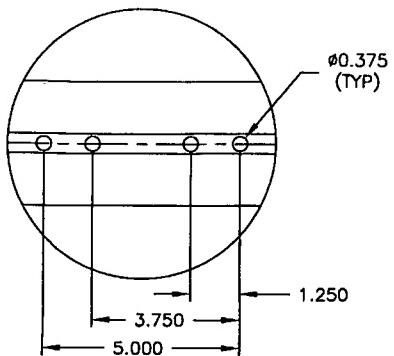
07.02.12 ~~07~~

ANSWER

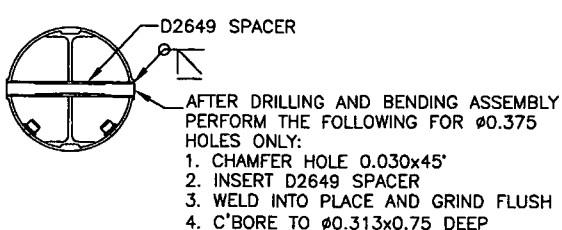
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COPYRIGHT © 2004 BY DART AEROSPACE USA, INC.		DESIGN	DRAWN BY	DART	DART AEROSPACE USA, INC. PORT HADLOCK, WA
		CP	PH		
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		#	#	D3274	SHEET 3 OF 4
		DATE	TITLE		SCALE
		06.12.19	SKIDTUBE ASSEMBLY		1:15

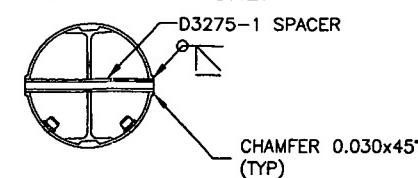
DETAIL A: DRILL DETAIL



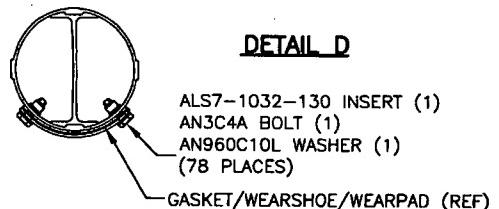
DETAIL B
FOR #0.375 HOLES ONLY



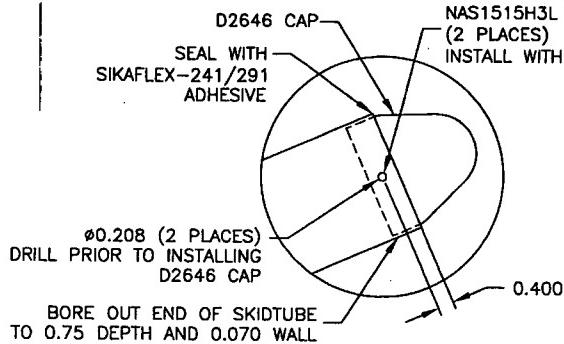
DETAIL C
FOR #0.313 HOLES ONLY



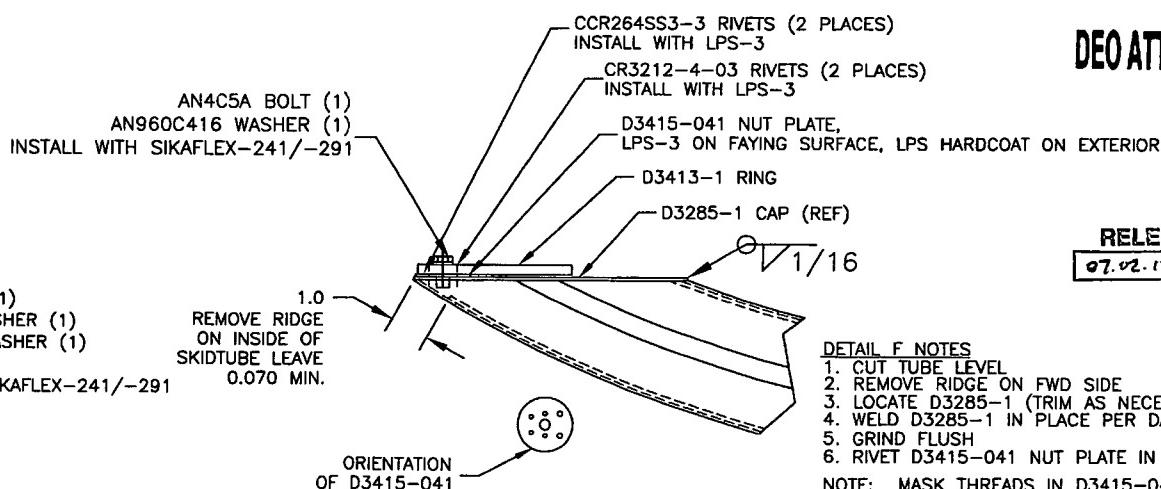
DETAIL D



DETAIL E



DETAIL F: END FINISHING DETAIL



DET ATTACHED

RELEASED

07.02.12

w/0 57357

DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

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	DATE 06.12.19	TITLE SKIDTUBE ASSEMBLY	SHEET 4 OF 4	SCALE 1:3

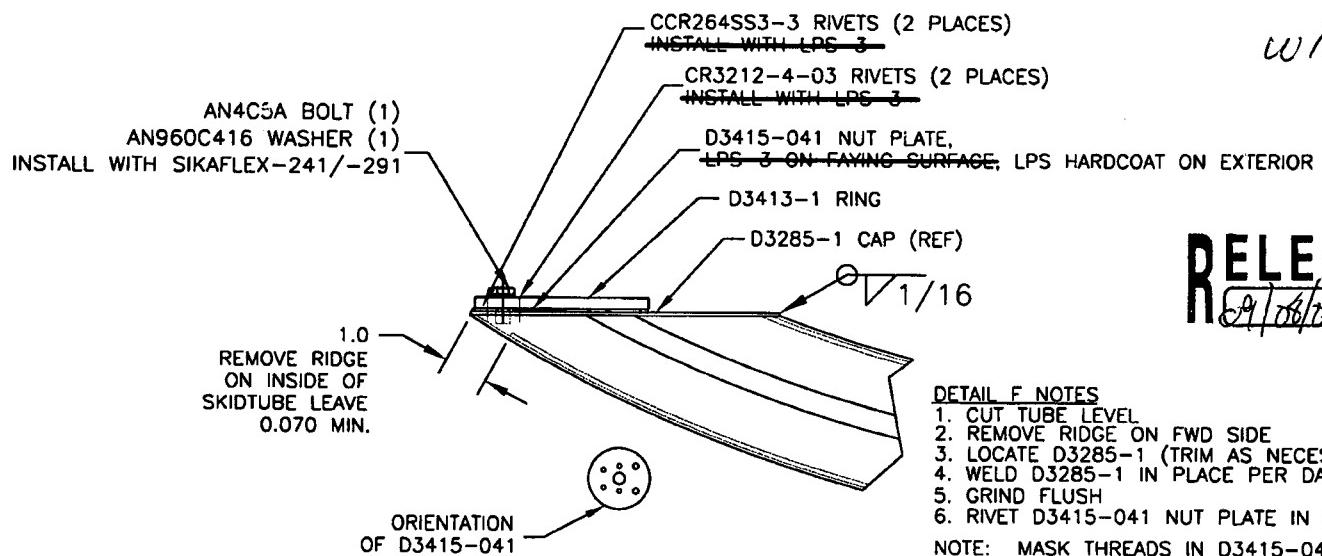
DRAWING NO. D3274	TITLE SKIDTUBE ASSEMBLY	REV. D	DART AEROSPACE USA, INC ENGINEERING ORDER	D.E.O. NO. D3274-D-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>CP</i>	CHECKED <i>M</i>	MFG. APPR. <i>M</i>	APPROVED <i>NAP</i>	DE APPR. <i>#</i>		
DATE 09.06.17	DATE 09.06.23	DATE 09/06/23	DATE 09/06/23	DATE 09/06/23	DATE 09.06.23	

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF SKIDTUBE.

AMEND NOTE 8: "~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES 'LPS-3' AFTER FINISH AND INSTALLATION OF INSERTS.~~
~~COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES 'LPS PROCYON' AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF~~
~~POWDER COATING WITH MEK DEGREASER."~~

AMEND DETAIL F AS SHOWN:

DETAIL F: END FINISHING DETAIL



NO 230

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 57358
Part number: DAC6-612-541
Description: float tube
Welding Process: Tig Mig
Base material: Aluminium
Current: AC DC

TEST REQUIREMENTS AND RESULTS

Visual: pass [✓] fail []
Penetration: pass [✓] fail []

UNACCEPTABLE

Cracks: pass [✓] fail []
Undercut: pass [✓] fail []
Pin holes: pass [] fail []
Overlap (cold lap) pass [✓] fail []
Porosity (surface): pass [✓] fail []
Coloration: pass [✓] fail []

Qualifier Barclay Elliott Date of Test Coupon 10.05.05

Welder Barclay Elliott Date of Test Coupon 10-05-05

The above named individual is qualified in accordance with AWS D17.1.2001 to weld